

Work Order ID 54185

December 2, 2009 11:15:40 AM



Page 1

Item ID: D2952-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: Basket Lid, 407

Start Date: 02/12/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *RL*

Date: *09-12-2*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2952

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2952-11 corner gussets as per Dwg D2952 2-Drill holes in D2952-3 as per Dwg D2952. 3- Debur & Remove any Markings From Material 4-Weld as per Dwg D2952 as per QSI 004. Debur as required A/R AL

ROD Batch: *M 108436*

110

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

120

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

SL 09/12/16

PD 09.12.16

2) 5 09/12/16

(FI)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
140 Large Fab Large Fab	Large Fab Memo 1-Assemble Label Plate as per Dwg D2952	0.00 0.00							
150 QC Quality Control	QC5- Inspect part completeness to step on W/O QC3 Memo	0.00 0.00							

SY 09/12/17

SY 09/12/17

27.8 or 12/18

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 54185

December 2, 2009 11:15:41 AM



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Item ID: D2952-041
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Item Name: Basket Lid, 407

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Setup Start
Stop



Start Date: 02/12/2009 Start Qty: 1.00
Required Date: 09/12/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Run Start
Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Powdercoat
Powder Coating

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

0.00

M113 170.

Memo

0.00

FIRST COAT: ☐ START TIME: *8:55* ☐ OVEN
TEMPERATURE: *320°* ☐ FINISH TIME: *9:25* ☐ 2ND
COAT (IF NECESSARY): ☐ START TIME: ☐ OVEN) *N/A*
TEMPERATURE: ☐ FINISH TIME: _____

BR 09-12-18 ①



QC
Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

M 09-12-22

(XL) 3



Packaging
Packaging

Identify as per dwg & Stock Location: *W/O 54182*

0.00

Memo

0.00

1

10-01-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

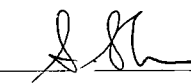


QC

Memo

0.00

Quality Control

 10-01-05

mf
10-01-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

December 2, 2009 11:15:47 AM

Work Order ID: 54185

Parent Item: D2952-041RevC

Parent Item Name: Basket Lid, 407

Start Date: 02/12/2009

Required Date: 09/12/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2953-077RevA		Manufactured	No			100	Each	38.0000	2.0000			
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Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

38

36032

38

D2953-175RevA

Manufactured No



Spacer

100	Each	3.0000	1.0000
-----	------	--------	--------



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

3

22096

3

D2957RevB

Manufactured No



Mounting Plate

100	Each	9.0000	6.0000
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Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

9

29869

2

36399

7

2x SH 09/12/07

1x SH 09/12/07

6x SH 09/12/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 54185



Parent Item: D2952-041RevC



Parent Item Name: Basket Lid, 407

Start Date: 02/12/2009

Required Date: 09/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M5052H32S.080

Purchased

No

100

sf

121.5918

0.0658



5052-H32 .080 Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

121.5918

100682

9

100742

68.5918

100947

37.21

19052

2

19729

4.79

.0658

SM 09/12/08

M6061T6TS0.750W.06

Purchased

No

100

f

311.9300

39.4737

2



6061-T6 SQ Tube .75 x .75 x .062W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

311.93

103069

147.94

104422

111.25

16441

18.74

9671

34

39.4737

SM 09/12/07

EUD BAR

SCRAP B 104422 — 2 feet"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

December 2, 2009 11:15:47 AM

Work Order ID: 54185

Parent Item: D2952-041RevC

Parent Item Name: Basket Lid, 407

Start Date: 02/12/2009

Required Date: 09/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS20600-AD4W2		Purchased	No			100	Each	484.0000	34.0000			
---------------	--	-----------	----	--	--	-----	------	----------	---------	--	--	--



Rivet

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	484	
109059	84	
111359	200	
112794	200	

34 SY 09/12/17

D2983RevA

Manufactured No



Lable Plate

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	6	
32023	6	

1x SY 09/12/17

M1100H14ES-
3/4X.051F

Purchased No



Alum Expanded Metal

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
MAT	42	
15444	42	

15444 SY 09/12/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

D2952-041 BASKET LID ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D2952-041	BASKET LID ASSEMBLY
2	D2952-1	FRAME MEMBER
2	D2952-3	FRAME MEMBER
3	D2952-5	FRAME MEMBER
2	D2952-7	FRAME MEMBER
4	D2952-9	FRAME MEMBER
4	D2952-11	GUSSET
1	D2953-175	SPACER
2	D2953-077	SPACER
6	D2957	MOUNTING PLATE
1	D2983	LABEL PLATE
A/R	M1100EX0.75-051F	3/4 #0.051F 1100 EXPANDED METAL
34	MS20600AD4W2	RIVET

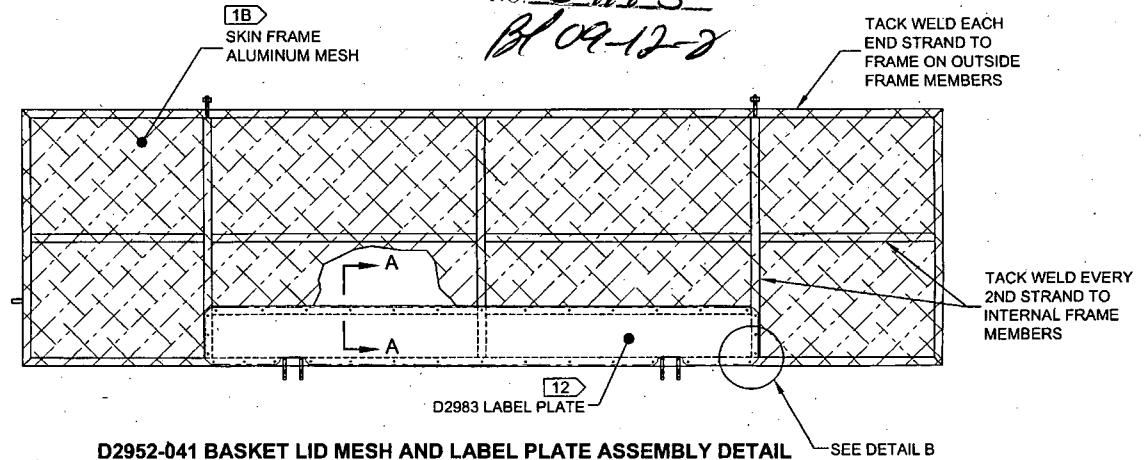
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 54185

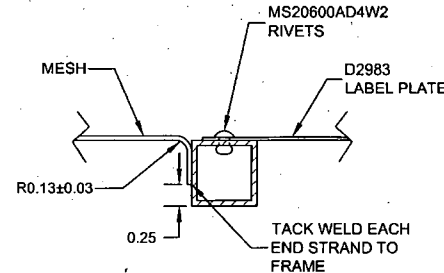
09-12-2



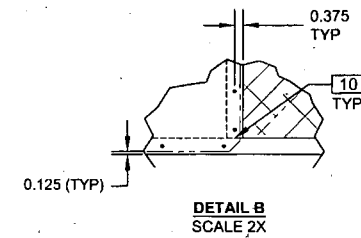
D2952-041 BASKET LID MESH AND LABEL PLATE ASSEMBLY DETAIL

NOTES:

- MATERIAL: A) FRAME: 6061-T6 (OR T651/T6510/T6511/T62) 0.75 X 0.75 X 0.062 WALL SQUARE TUBING PER QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (AMS 4160) (REF. DART MATERIAL SPEC M6061T6TS0.750W.062)
B) MESH: 5005-H34 OR 3003-H14 OR 1100-H14/H18, 3/4 #0.051F EXPANDED METAL (FLATTENED) (REF. DART MATERIAL SPEC M1100EX0.75-051F)
C) GUSSET: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 (OR AMS 4025/4027) (REF. DART MATERIAL SPEC M6061T6S.080)
OR 5052-H32 ALUMINUM SHEET 0.080 THICK PER QQ-A-250/8 (OR AMS 4016) (REF. DART MATERIAL SPEC M5052H32S.080)
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: N/A
- WEIGHT: 9.8 lbs
- WELD PER DART QSI 004
- GRIND 0.063 MAX X 45° CHAMFER BEFORE WELDING CORNERS (TYP, 4 PLACES)
- GRIND WELDS FLUSH ON TOP SIDE FOR LABEL PLATE
- GRIND CORNER WELDS ON BOTTOM SIDE OF BASKET FOR GUSSET (TYP, 4 PLACES)
- TRANSFER D2983 LABEL PLATE HOLES USING Ø0.128 DRILL, INSTALL D2983 ONTO LID USING MS20600AD4W2 RIVETS (34 PLACES)



SECTION A-A
SCALE 8X



DETAIL B
SCALE 2X

C	FRAME MATERIAL NOW 0.062 WALL (WAS 0.065 WALL); ADD M-DRAWING NOTES; ADD D2952-11 GUSSET DRAWING (ZONE A4-2); UPDATE DRAWING FORMAT; NOW 2 PAGES; REASON: DRAFTING ERROR	PH	08.02.19
B	CHANGE FROM SHEET TO MESH; ADD D2952-7/-9/-11	RF	00.07.06
A	NEW ISSUE	RF	00.01.14
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	LE	DRAWING NO.	REV. C
MFG. APPR.	MS	D2952	SHEET 1 OF 2
APPROVED	MS	TITLE	SCALE
DE APPR.	MS	BASKET LID ASSEMBLY	NTS
DATE	08.02.19	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR THE DISSEMINATION OF INFORMATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

